

WHAT IS CLAIMED IS:

1. A brassiere for supporting a wearer's breasts comprising:

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a pair of breast cups with each of said pair of breast cups connected to a central panel, said central panel being disposed between said pair of breast cups; and

10 a pair of side panels, each being connected to a separate one of said pair of breast cups, wherein said pair of breast cups have a first fabric layer, a second fabric layer and a third fabric layer disposed between said first fabric layer and said second fabric layer, and wherein said third fabric
15 layer provides breathability to the wearer's breasts and support to said pair of breast cups, wherein said third fabric layer has a first side and a second side, said third fabric layer having a plurality of perforations in a location of said third fabric layer.

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2. The brassiere of claim 1, wherein said location is selected from the group consisting of said first side, said second side, both said first side and said second side, a portion of said first side, a portion of said second side, and
25 any combinations thereof.

3. The brassiere of claim 1, wherein said third fabric layer has a plurality of perforations, said plurality of perforation forming a pattern, said pattern being visible
30 through said first fabric layer.

4. The brassiere of claim 3, wherein said pattern is selected from the group consisting of a floral pattern, a flower, a plurality of flowers, a heart, a plurality of hearts, a spiral, a plurality of spirals, a free-form design, a message, a plurality of numbers, a plurality of letters, a logo, and any combinations thereof.

5. The brassiere of claim 1, wherein said third fabric layer has a feature selected from the group consisting of a plurality of dimples, a plurality of valleys, and any combinations thereof.

6. The brassiere of claim 1, wherein said third fabric layer is made from a material selected from the group consisting of a mono-filament material, a multi-filament material, a polyester, a microfiber, a cotton, a nylon, a spandex, a Lycra, a power mesh material, a multi-filament polyester spandex, a molded fabric material, a weft knit fabric, a warp knit fabric, and any combinations thereof.

7. The brassiere of claim 1, wherein said third fabric layer is connected between said first fabric layer and said second fabric layer, said third layer being connected by a method selected from the group consisting of sewing, gluing, riveting, molding, ultrasonic connection, a mechanical connection, and any combinations thereof.

8. The brassiere of claim 1, wherein said third fabric layer is connected peripherally to said first fabric layer and said second fabric layer, wherein said third fabric layer is

substantially enclosed between said first fabric layer and said second fabric layer.

9. An article of clothing for covering a wearer's breasts
5 comprising:

a first breast cup;

a second breast cup;
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a center gore being disposed between said first breast cup and a second breast cup, said first breast cup and said second breast cup having an outer layer of fabric; and

15 a spacer fabric layer being disposed on said outer layer of fabric when the article of fabric of clothing is position on the wearer, said spacer fabric layer is positioned between said outer fabric layer and the wearer's breasts, wherein said spacer fabric layer provides breathability to the wearer's
20 breasts, and wherein said spacer fabric layer has a first side and a second side, said spacer fabric layer having a plurality of perforations on a location of said spacer fabric layer.

10. The article of clothing of claim 9, wherein said
25 spacer fabric layer has a first surface, said first surface facing the wearer's breasts, said first surface being substantially smooth relative to a second surface, said second surface being opposite said first surface.

30 11. The article of clothing of claim 9, wherein said plurality of perforations are on a portion of the spacer

5 fabric layer that correspond to a location where the wearer's
breasts lay, said plurality of perforations allowing a
predetermined amount of air to substantially traverse through
said spacer fabric layer, said predetermined amount of air
being suitable to cool the wearer's breasts during exercise.

10 12. The article of clothing of claim 9, wherein said
spacer fabric layer has a feature selected from the group
consisting of a plurality of dimples, a plurality of valleys,
a concave surface, a convex surface, an aperture, a hole, and
any combinations thereof.

15 13. The article of clothing of claim 12, wherein said
feature is formed in a pattern, said pattern being selected
from the group consisting of a floral pattern, a flower, a
plurality of flowers, a heart, a plurality of hearts, a
spiral, a plurality of spirals, a free-form design, a message,
a plurality of numbers, a plurality of letters, a logo, and
any combinations thereof.

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14. The article of clothing of claim 9, wherein said
spacer fabric layer and said outer fabric layer are formed
from a material being selected from the group consisting of a
mono-filament material, a multi-filament material, a
25 polyester, a microfiber, a cotton, a nylon, a spandex, a
Lycra, a power mesh material, a multi-filament polyester
spandex, a molded fabric material, a weft knit fabric, a warp
knit fabric, and any combinations thereof.

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15. An article of clothing for covering over a wearer's
breasts comprising:

a first fabric layer;

a second fabric layer; and

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a spacer fabric layer being enclosed between said first fabric layer and said second fabric layer, wherein said spacer fabric layer provides breathability to the wearer's breasts, and wherein said spacer fabric layer has a pattern, said
10 pattern being visible through at least one of said first fabric layer and said second fabric layer, said pattern being disposed on a first location, said first location corresponding to a second location where the wearer's breasts lay.

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16. A method of making an article of clothing, the method comprising the steps of:

molding a spacer layer into a pair of breast cups using a
20 mold, said mold being heated to a temperature, said temperature being in a range that includes about 400 degrees Fahrenheit for a time period, said time period being in a range that includes about 50 to about 55 seconds;

25 positioning said spacer layer under a single headed device, said single headed device having an anvil and a horn, said anvil having a cutting edge and an embossing area;

mating said horn and said anvil with said spacer layer
30 being between said anvil and said horn, said cutting edge cutting a pattern in said molded spacer layer by cutting a

plurality of perforations in said spacer layer, each of said plurality of perforations of said pattern having an edge;

5 applying ultrasonic energy to said spacer layer so that said edge of each of said plurality of perforations of said pattern formed in said spacer layer is sealed; and

10 stitching said spacer layer having said pattern between a first fabric layer and a second fabric layer, wherein said pattern is visible through at least one of said first fabric layer and said second fabric layer.

15 17. The method of claim 16, wherein said cutting edge and a surface of said anvil form an angle, said angle being in a range that includes about one hundred twenty degrees, said range for substantially eliminating a shear stress on said molded spacer fabric during said cutting.

20 18. The method of claim 16, wherein said ultrasonic energy has a frequency, said frequency being in a range that includes about 10 kilohertz to about 50 kilohertz.

25 19. The method of claim 16, wherein said horn has a coating being on said horn, and said mold is an impression mold.

30 20. The method of claim 16, further comprising the step of rotating said spacer layer when mating said horn with said anvil, said spacer layer being between said anvil and said horn, said rotation causing a plurality of patterns to be formed on said spacer layer.